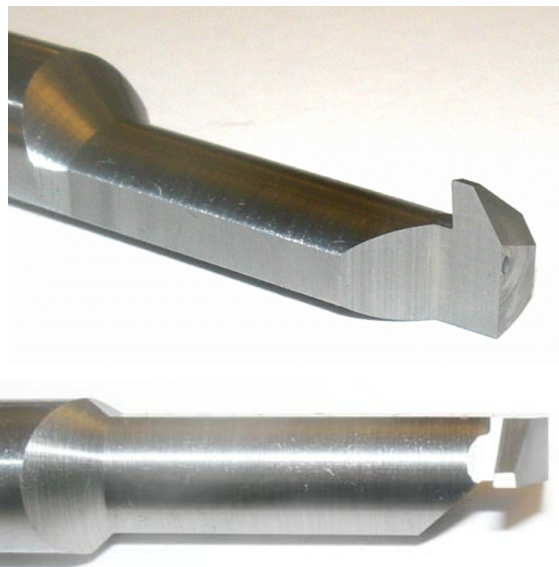


ID Turning tool with dxQ Profile

A17-01 0

This turning tool with excentric shaft is used for turning small pieces on high precision lathe machines. The tool is ground out of a blank with Ø8x50mm. The excentric profile grinding option of Quinto allows to grind the excentric shaft based on DXF. In order to obtain the shaft length of 18 mm, tree excentric operations with axial shift have been used. The grinding time can be considerably reduced by using a wheel which avoids shifting. The main profile is ground with dxQ operations of Quinto.



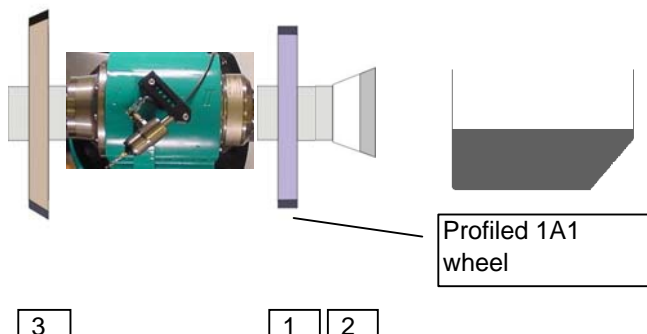
1. Cycletime for Production

Workpiece: Diameter 8 mm, Z 1, Length 20.5 mm Material CARBIDE							
Operations							
Feed [mm/Min]	2000	100	45	45	45	55	35
No. Of cycles		3	2	1	1	1	1
Cutting feed [m/s]		22	24	24	22	22	22
Used wheels							
Grinding time [s]	6	323	106	53	40	113	126
Total cycle time	12 Min 48 min						

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1A1 Ø125 D64
2	11V9 Ø75 D64
3	1V1 Ø125 D46



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG / Gemini DMR
 Control: Fanuc 160i
 Accessories:

Coolant: Synthetic Oil, pressure 6 bar
 Software: Quinto 4.3

Responsible engineer: SIW, 22.12.2009

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J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland
 Subsidiaries in: France, Deutschland, Italia, United States, UK, China